

Date: Tuesday, 13/01/2009 9:22:17 AM  
User: Julie Dawson

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: REAR OVERHEAD L/H
Job Number	: 44718		
Estimate Number	: 13589		
P.O. Number	:	Part Number	: D38231
This Issue	: 13/01/2009 S.O. No. :	Drawing Number	: D38231 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: IN0002
First Issue	: 1/1 Type : R&D THERMOFORMING	Drawing Revision	: A UNDER REVIEW
Previous Run	: 43179	Material	: MKYD6185S080P362015
Written By	:	Due Date	: 20/01/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>Julie Dawson</u>		
Comment	: Est. A New Issue 08/09/17 DL		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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Comment: Qty.: 11.3747 sf(s)/Unit Total : 22.7493 sf(s) M109703  
6185 Kydex .080"

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/01/14

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/01/14 (X2) (+2)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3823-1 and folio (FTA 9112 Prototype) using tool DT 9112

Dwg. Rev. A

Folio Rev. A

BB 09/01/14 (X2) (+2)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/01/14 (X2) (+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: REAR OVERHEAD L/H

Job Number: 44718

Part Number: D38231

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



~~BB 09/04/15~~



Comment: SECOND CHECK

BB 09.01.16 X2

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

BB 09/04/15  
PTO

(X2)

1) Trim to Finished Dimensions

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/15 (X2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

BB 09.04.14

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

BB 9/4/15 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15 AG

Job Completion



U 9.04.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.01.14	7	<del>DIMENSION "0.44 MIN" IS</del> N/A PH 09.04.15					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 44718
<b>Description:</b> Rear overhauled LH	<b>Part Number:</b> D3823-1
<b>Inspection Dwg:</b> D3823-1 Rev: <del>A</del> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article    ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention		✓		
Material imperfections such as bumps, cracks, voids, scratching		✓		

<b>Measured by:</b> <i>JOS 01.14</i>	<b>Date:</b>
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	min	0.6	✓		vern.	
0.9 (Ref)		0.9	✓			
0.18 (Ref)		0.34		✓		revise Mold sec.
1.75	min	1.77	✓		vern.	
0.44	min.	0.46	✓		vern	
35.94 (Ref)		35.9	✓		Tape	
14.3 (Ref)		14.35	✓		Tape.	
0.045	min thickness	0.061	✓		m/c.	

<b>Measured by:</b> <i>JOS 01.14</i>	<b>Date:</b>
<b>Audited by:</b> <i>PH</i>	<b>Date:</b> 09/04/15
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

OK  
UPDATE  
DNG  
RA  
09.04.14

8

7

2

1

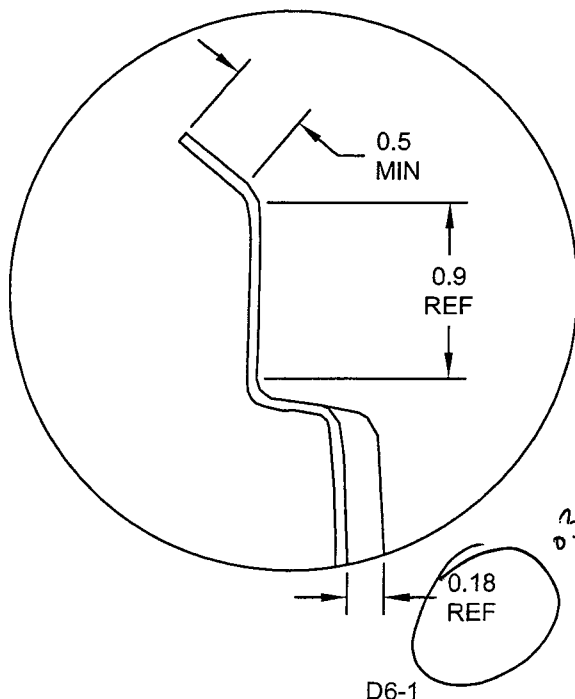
D

D

MIN THICKNESS  
0.045  
(SHADED REGION)

C

C

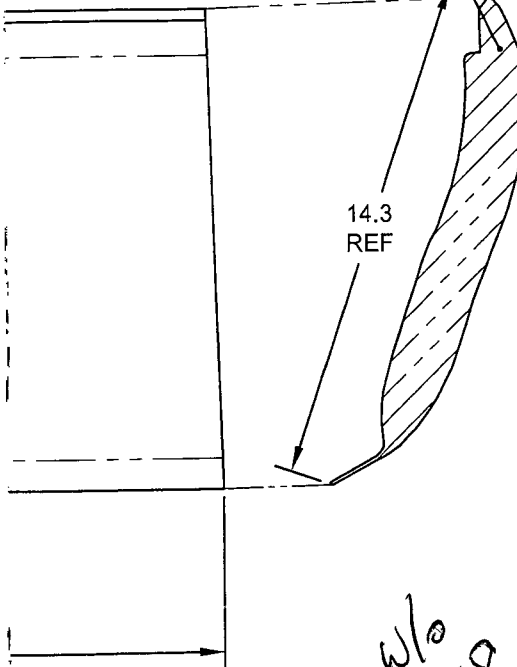


**DETAIL B**  
SCALE 5X

D6-1

0.18  
REF

034



RELEASED  
10/21/12

B

**NOTES:**

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MA  
(REF DART SPEC MKYD6185S.080-P3-6201)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3823-1"
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

DESCRIPTION

PH 08.09.26  
BY DATE

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D3823

REV. A  
SHEET 1 OF 3

TITLE  
REAR OVERHEAD

SCALE  
NTS

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8

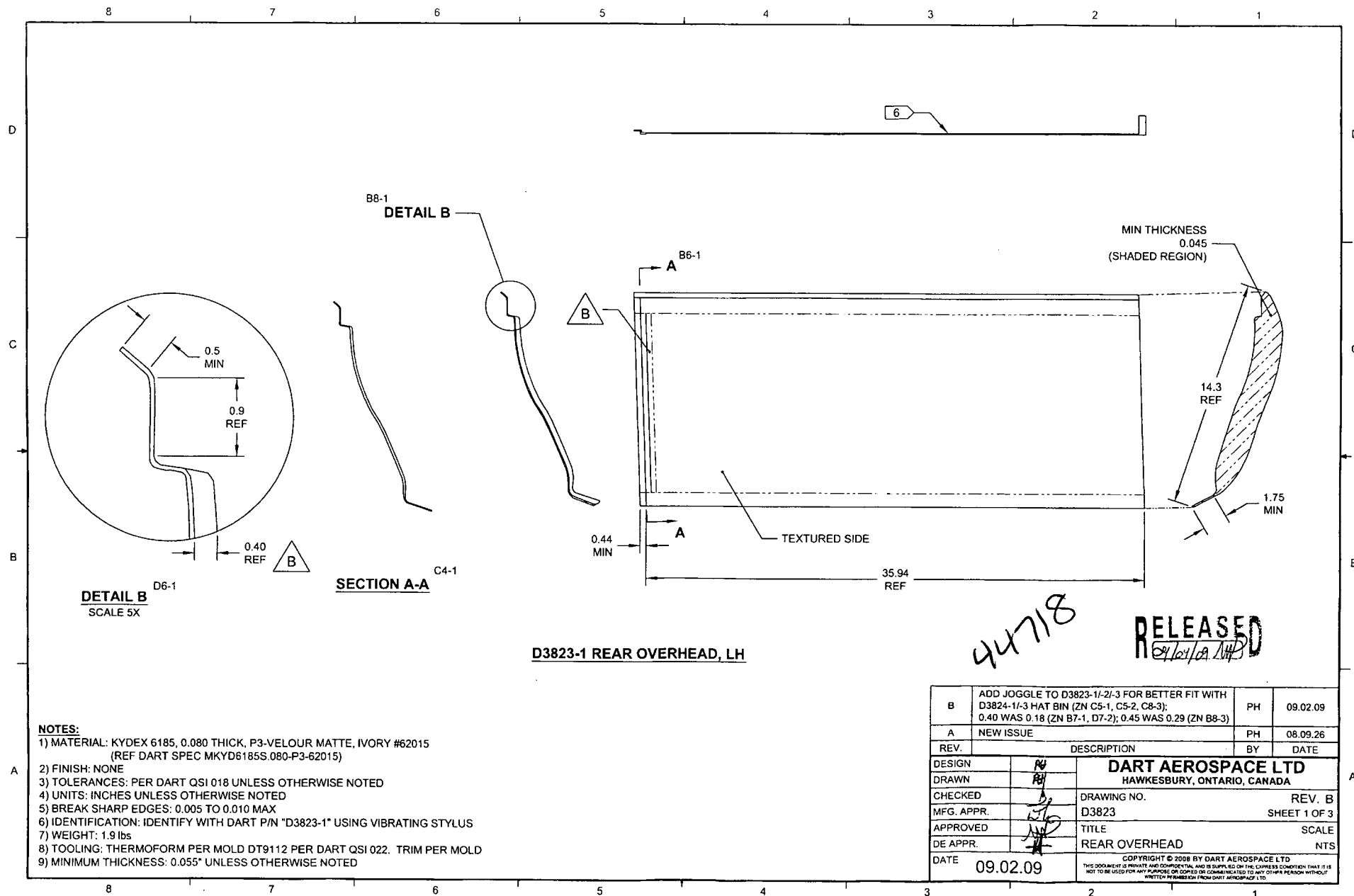
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2

1

A

A



**NOTES:**

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015  
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3823-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.9 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9112 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.055" UNLESS OTHERWISE NOTED

B	ADD JOGGLE TO D3823-1/2-3 FOR BETTER FIT WITH D3824-1/-3 HAT BIN (ZN C5-1, C5-2, C8-3); 0.40 WAS 0.18 (ZN B7-1, D7-2); 0.45 WAS 0.29 (ZN B8-3)	PH	09.02.09
A	NEW ISSUE	PH	08.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3823	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	REAR OVERHEAD	NTS
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